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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR27		N/C
N/C	INITIAL RELEASE	06-15-16	P. BRAVO
A	INCORPORATED ECN 05570	09-06-16	P. BRAVO
B	INCORPORATED ECN 05887	02-02-18	P. BRAVO
C	INCORPORATED ECN 06453	02-24-20	J. GARDINER

NOTES: UNLESS OTHERWISE SPECIFIED

- 1

DELETED
- 2

IDENTIFY IAW MPP-120
- 3

DEBURR AND BREAK ALL SHARP EDGES.
45° CHAMFER .015" TO .030" AROUND PART EXTERIOR EDGE
- 4

FINISH: BRUSHED
- 5

FINISH: IAW MPP-172 PRIMER IAW SECTION 4.2
- 6

DEBURR AND BREAK ALL SHARP EDGES.
45° CHAMFER .005" TO .010" AROUND PART EXTERIOR EDGE
- 7

100% LOT INSPECTION, CRITICAL FEATURE
- 8

INSTALL F/N 17, JOINING F/N 13 OR 14 WITH F/N 5 IAW NAS10997AD3-5 SPECIFICATIONS
- 9

MASK INSIDE OF F/N 5 BEFORE APPLYING PRIMER.
- 10

MATERIAL: HALF HARD 301 STAINLESS STEEL PER AMS 5518.
- 11

SCORE SURFACE, BEFORE APPLYING PRIMER, USING 40 GRIT SAND PAPER
- 12

PRIMER FINISH: PC 4426, VENDOR: ROYAL ADHESIVES & SEALANTS
- 13

DIMENSIONS FOR FLAT PATTERN DRIVEN BY .DXF FILE
- 14

MATERIAL: P/N 600.0025, SEE SPEC AMS-021 REV B
- 15

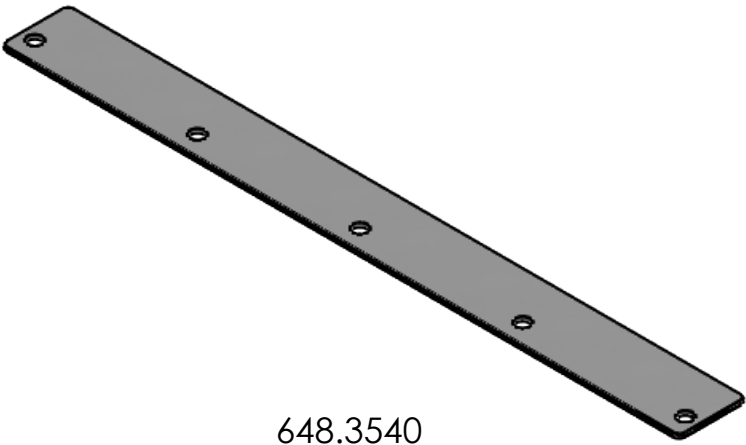
MATERIAL: 316 STAINLESS STEEL PER AMS 5524
- 16

MATERIAL: 304 STAINLESS STEEL IAW 5640, 0.016" THICKNESS

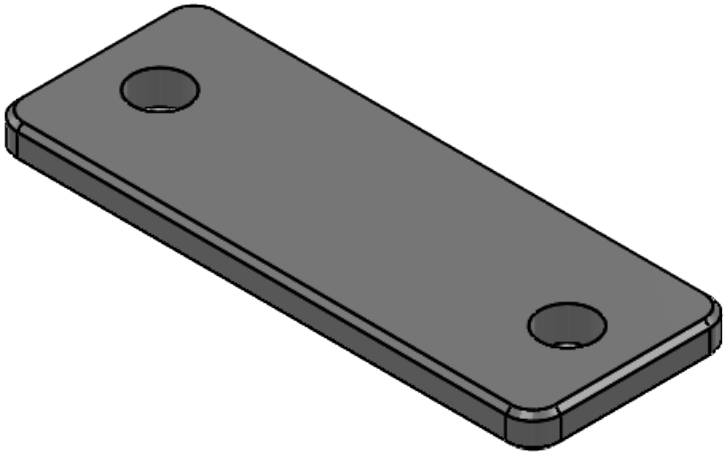
UNDER REVIEW
ECR 1516 -23.05.09

		19	648.3548	DOOR PIN GUARD	<div>16</div>	
		18	648.3547	DOOR PIN GUARD	<div>16</div>	
12	12	17	601.3200	REDUCED CSK RIVET		NAS1097AD3-5
		16	648.3544	DOUBLER RUB STRIP	<div>14</div>	<div>13</div>
		15	348.3543	DOUBLER RUB STRIP	<div>14</div>	<div>13</div>
1		14	648.3542	RESERVOIR BRACKET DOUBLER	<div>15</div>	
	1	13	648.3541	RESERVOIR BRACKET DOUBLER	<div>15</div>	
		12	648.3540	FWD GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		11	648.3539	AFT FLT RH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		10	648.3538	AFT FLT LH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		9	648.3537	AFT RH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		8	648.3536	MID RH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		7	648.3546	GIRT BACKING STRIP	<div>10</div>	<div>4</div> <div>5</div>
		6	648.3545	GIRT BASE STRIP	<div>10</div>	<div>11</div> <div>12</div>
6	6	5	651.0601	BUSHING ASSY		
		4	648.3535	FWD RH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		3	648.3534	AFT LH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		2	648.3533	MID LH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		1	648.3532	FWD LH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
X		X	648.3506	BOTTOM AFT DOUBLER ASSY		<div>5</div> <div>9</div>
	X	X	648.3505	TOP FWD DOUBLER ASSY		<div>5</div> <div>9</div>
.3506	.3505	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY						
PARTS LIST						
NEXT ASSY (\$)		ORIGINAL DATE (MO-DA-YR) 08-19-10		<div><div><div>DART</div><div>AEROSPACE</div><div>APICAL INDUSTRIES, INC. dba DART AEROSPACE</div></div><div>3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300</div></div>		
		DRAWN BY E.ANDERSSON CHECKER P. BRAVO				
648.3300		DRAWING APPROVAL P. BRAVO 6-15-16				
		CONTRACT No.				
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SHEETMETAL		
				SIZE B	CAGE CODE 07MZ6	DWG. NO. 648.3500
				SCALE NONE		SHEET 1 OF 12

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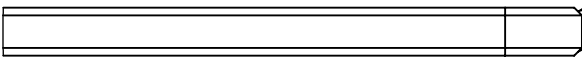
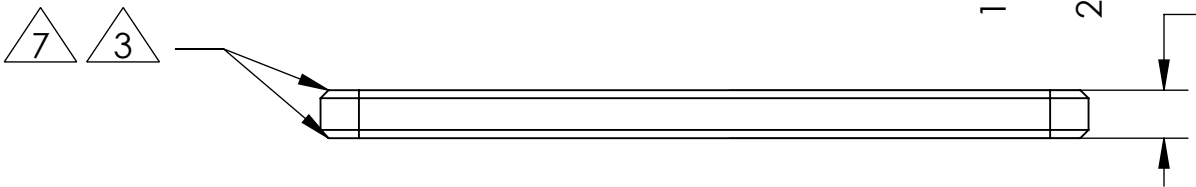
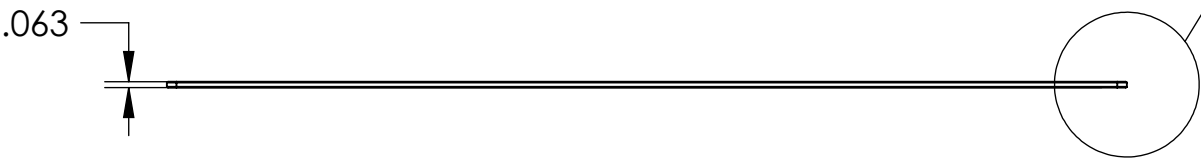
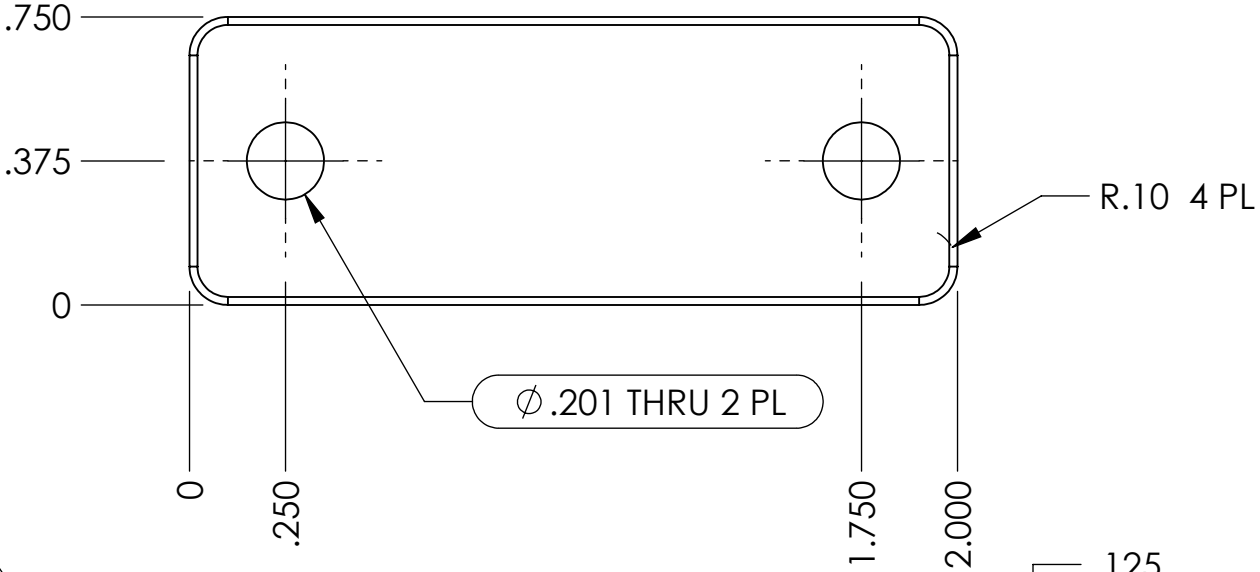
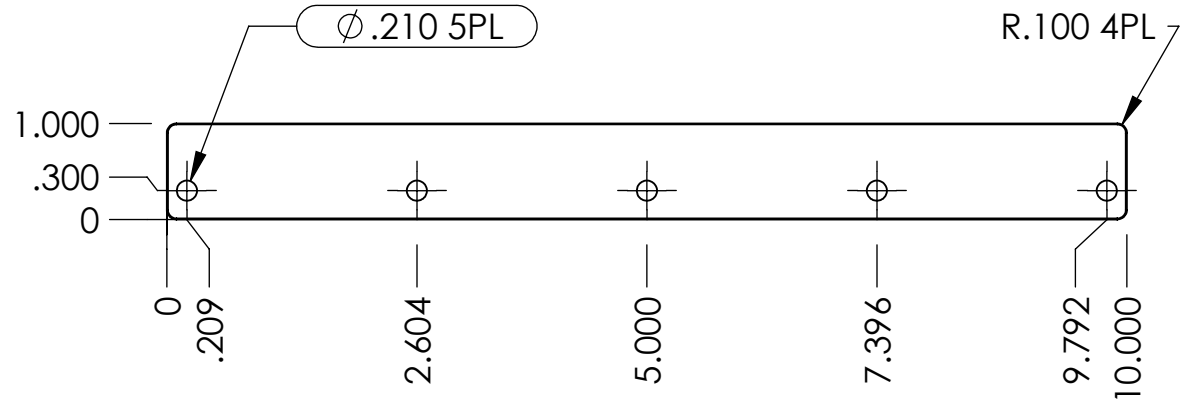


648.3540



648.3545

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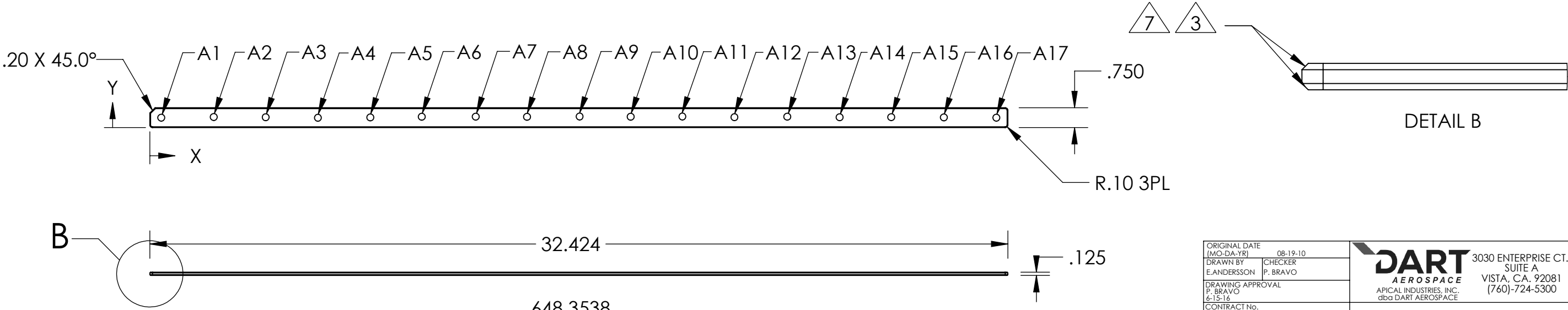
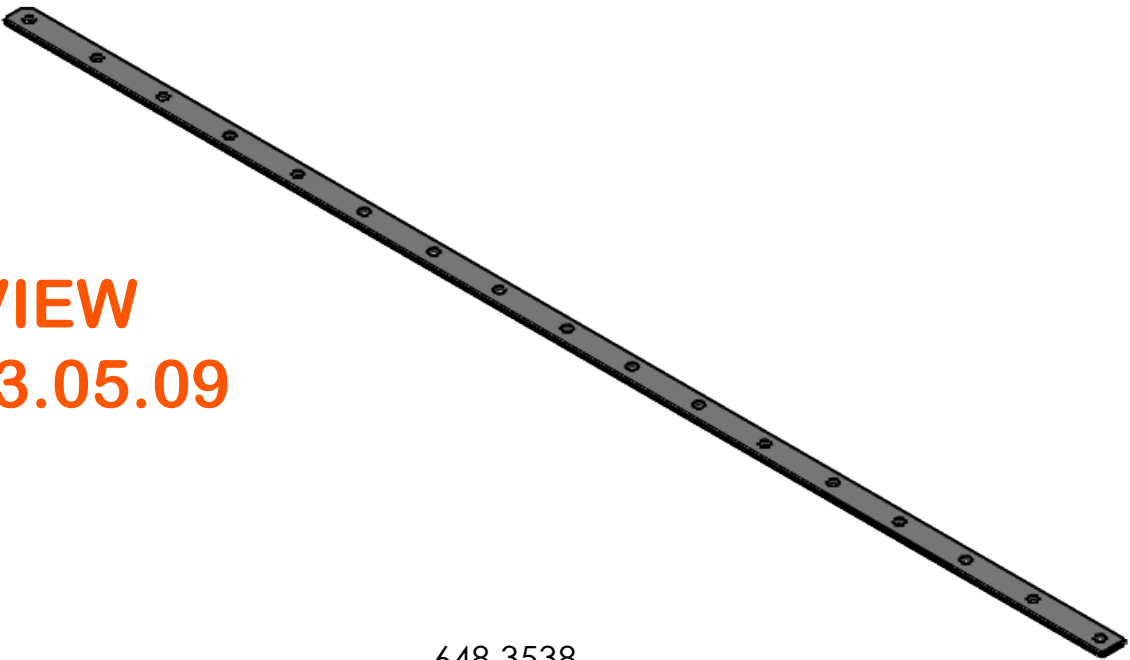
DETAIL A

ORIGINAL DATE (MO-DA-YR) 08-19-10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E.ANDERSSON	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 6-15-16		APICAL INDUSTRIES, INC. dba DART AEROSPACE	
CONTRACT No.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B	REV. C
		CAGE CODE 07MZ6	DWG. NO. 648.3500
		SCALE NONE	SHEET 2 OF 12

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TAG	X LOC	Y LOC	SIZE
A1	.434	.375	Ø .261 THRU
A2	2.418	.400	Ø .261 THRU
A3	4.379	.392	Ø .261 THRU
A4	6.352	.370	Ø .261 THRU
A5	8.332	.385	Ø .261 THRU
A6	10.275	.410	Ø .261 THRU
A7	12.316	.414	Ø .261 THRU
A8	14.254	.407	Ø .261 THRU
A9	16.241	.419	Ø .261 THRU
A10	18.170	.411	Ø .261 THRU
A11	20.124	.419	Ø .261 THRU
A12	22.092	.394	Ø .261 THRU
A13	24.089	.412	Ø .261 THRU
A14	26.067	.391	Ø .261 THRU
A15	28.017	.395	Ø .261 THRU
A16	30.006	.386	Ø .261 THRU
A17	31.990	.375	Ø .261 THRU

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ORIGINAL DATE (MO-DA-YR) 08-19-10		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E.ANDERSSON	CHECKER P.BRAVO	DART AEROSPACE APICAL INDUSTRIES, INC. dba DART AEROSPACE	
DRAWING APPROVAL P.BRAVO 6-15-16		SHEETMETAL	
CONTRACT No.		SIZE B	REV. C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		CAGE CODE 07MZ6	DWG. NO. 648.3500
		SCALE NONE	SHEET 3 OF 12

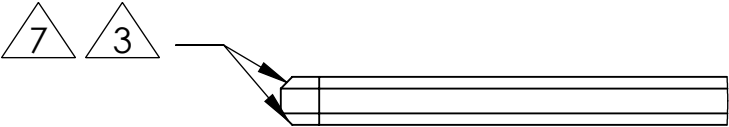
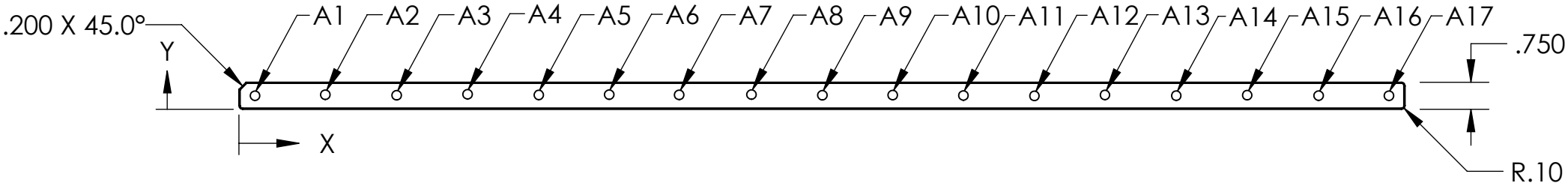
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TAG	X LOC	Y LOC	SIZE
A1	.444	.375	Ø .261 THRU ALL
A2	2.398	.402	Ø .261 THRU ALL
A3	4.384	.388	Ø .261 THRU ALL
A4	6.357	.415	Ø .261 THRU ALL
A5	8.336	.396	Ø .261 THRU ALL
A6	10.294	.405	Ø .261 THRU ALL
A7	12.240	.398	Ø .261 THRU ALL
A8	14.250	.407	Ø .261 THRU ALL
A9	16.221	.389	Ø .261 THRU ALL
A10	18.180	.394	Ø .261 THRU ALL
A11	20.145	.381	Ø .261 THRU ALL
A12	22.119	.370	Ø .261 THRU ALL
A13	24.080	.396	Ø .261 THRU ALL
A14	26.064	.377	Ø .261 THRU ALL
A15	28.036	.391	Ø .261 THRU ALL
A16	30.022	.378	Ø .261 THRU ALL
A17	31.980	.375	Ø .261 THRU ALL

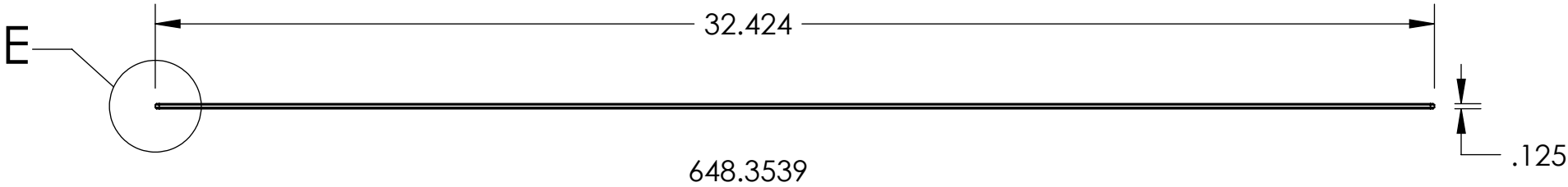
UNDER REVIEW
ECR 1516 -23.05.09



648.3539



DETAIL E



648.3539

ORIGINAL DATE (MO-DA-YR) 08-19-10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300		
DRAWN BY E.ANDERSSON	CHECKER P. BRAVO			
DRAWING APPROVAL P. BRAVO 6-15-16				
CONTRACT No.		SHEETMETAL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B 07MZ6	DWG. NO. 648.3500	REV. C
SCALE NONE		SHEET 4 OF 12		

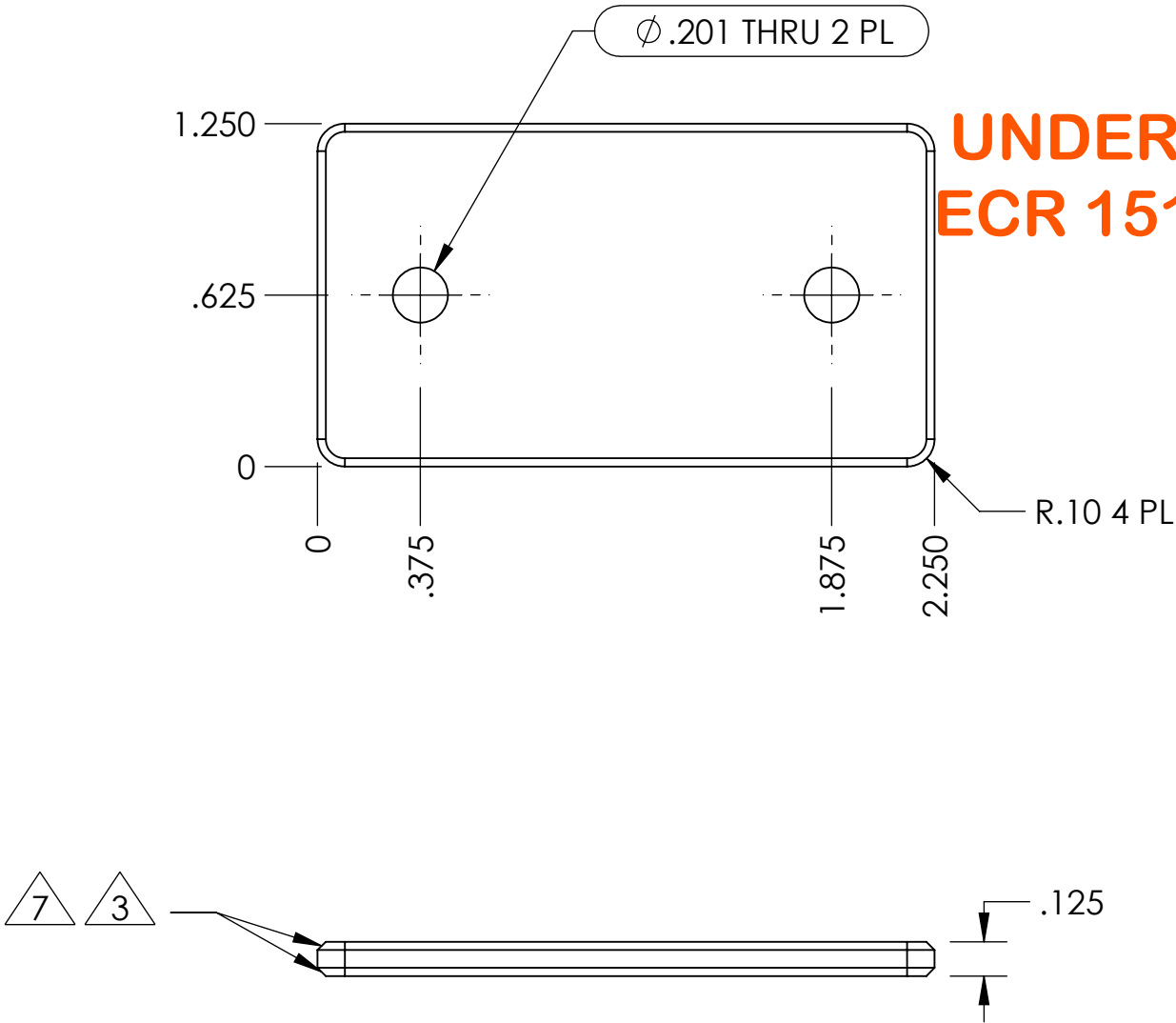
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A

B

C

D



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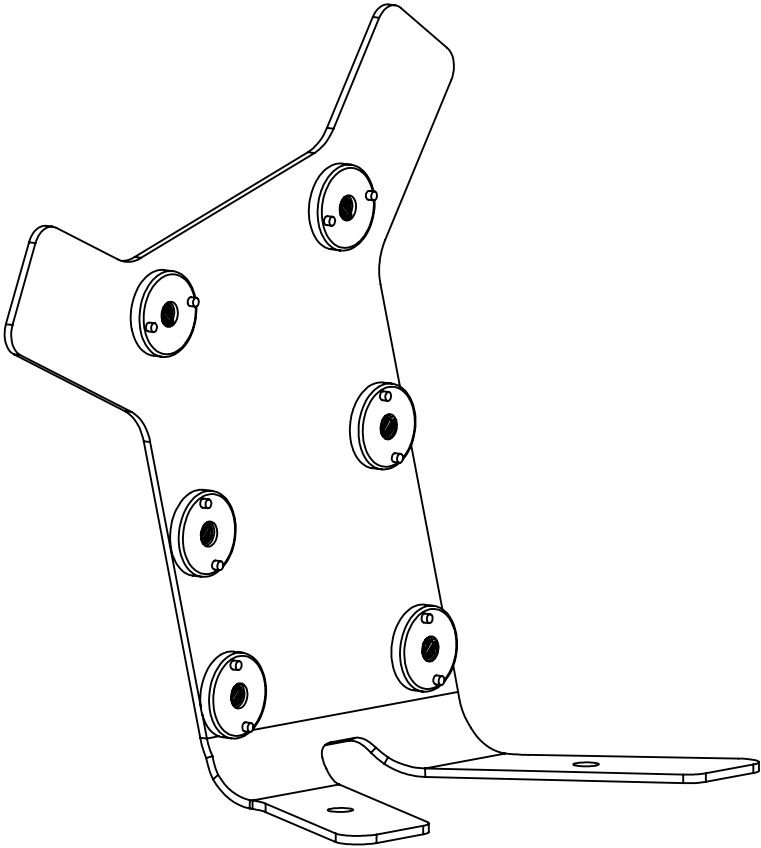
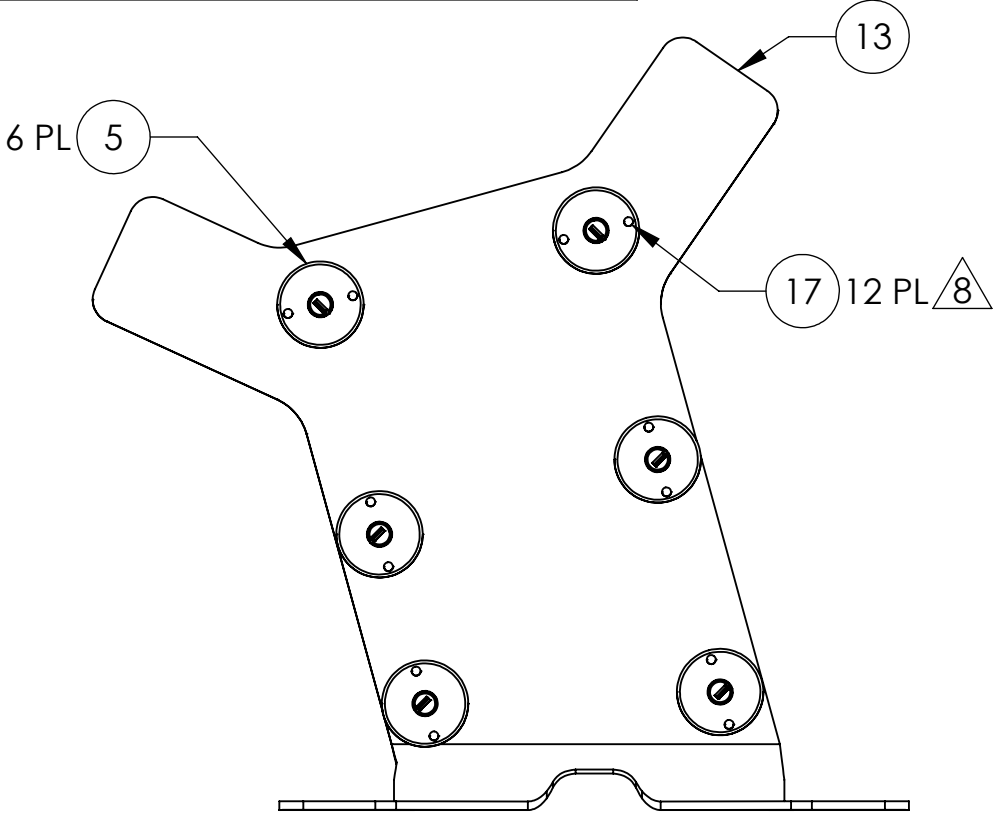


648.3546

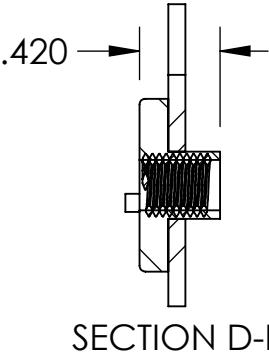
ORIGINAL DATE (MO-DA-YR) 08-19-10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E. ANDERSSON	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 6-15-16		SHEETMETAL	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B	REV. C
		CAGE CODE 07MZ6	DWG. NO. 648.3500
SCALE NONE		SHEET 5 OF 12	

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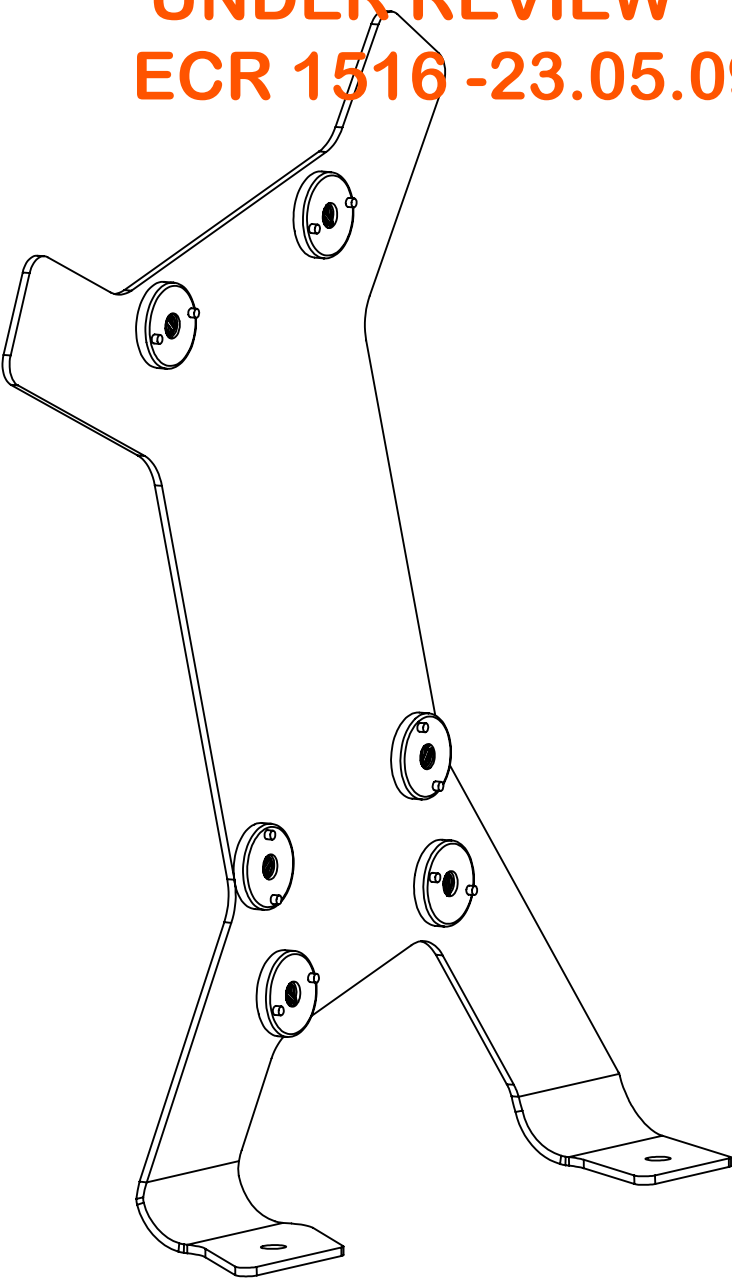
A
B
C
D



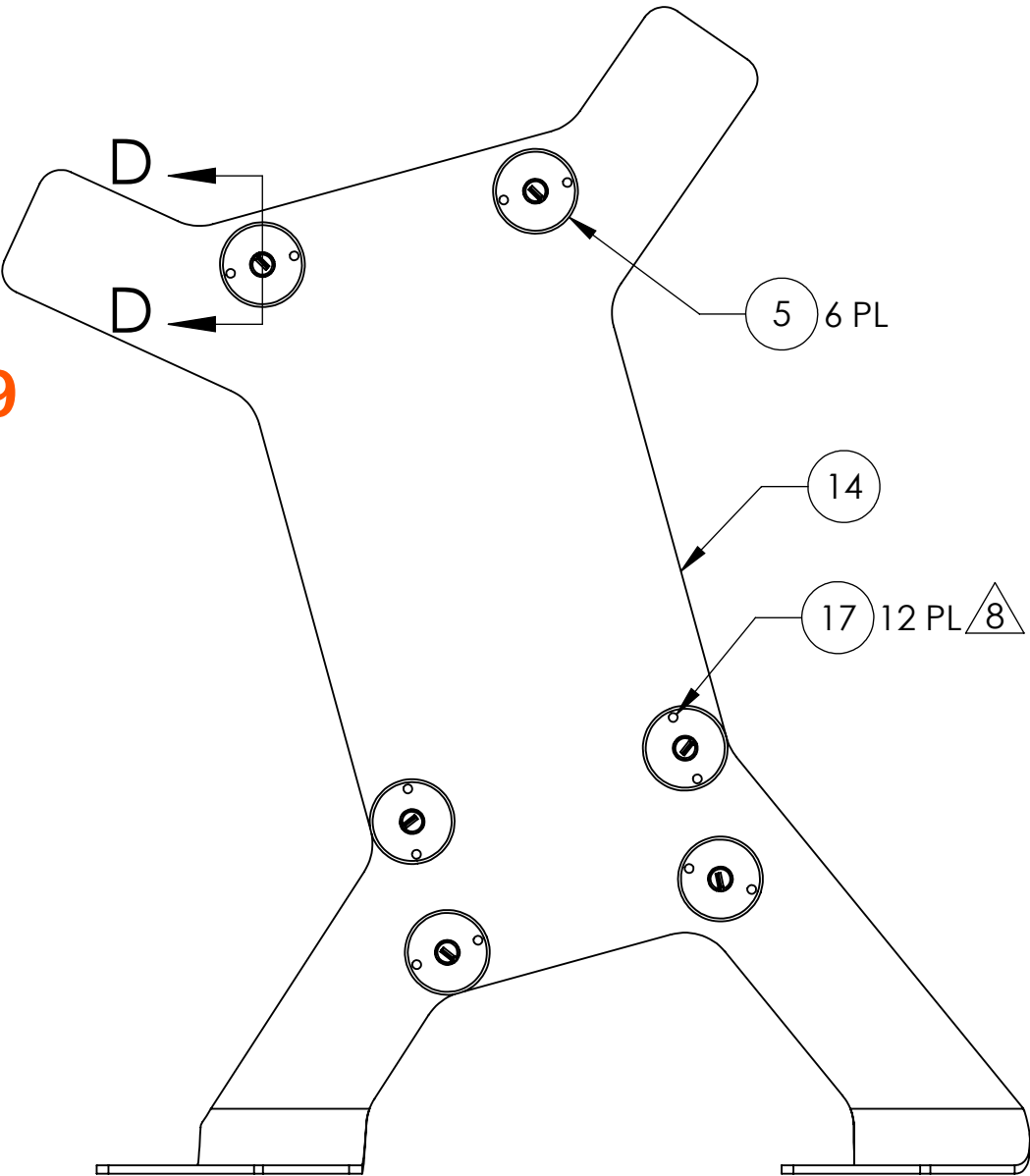
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ECR 1516 -23.05.09

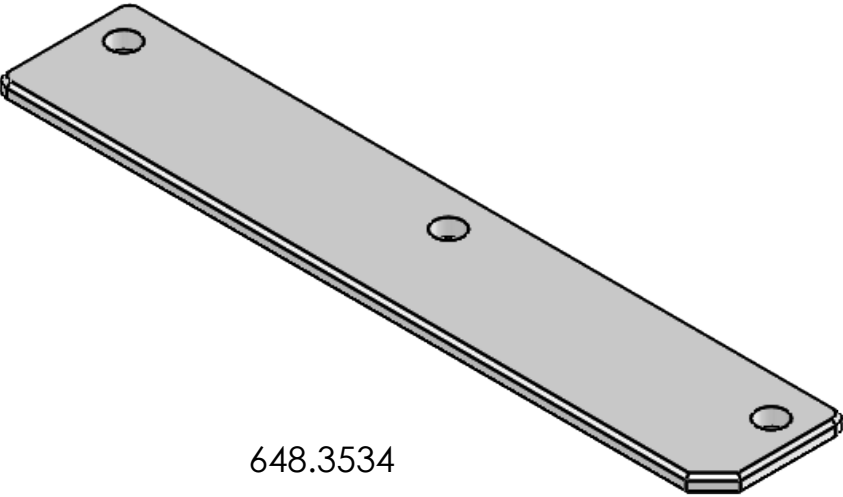
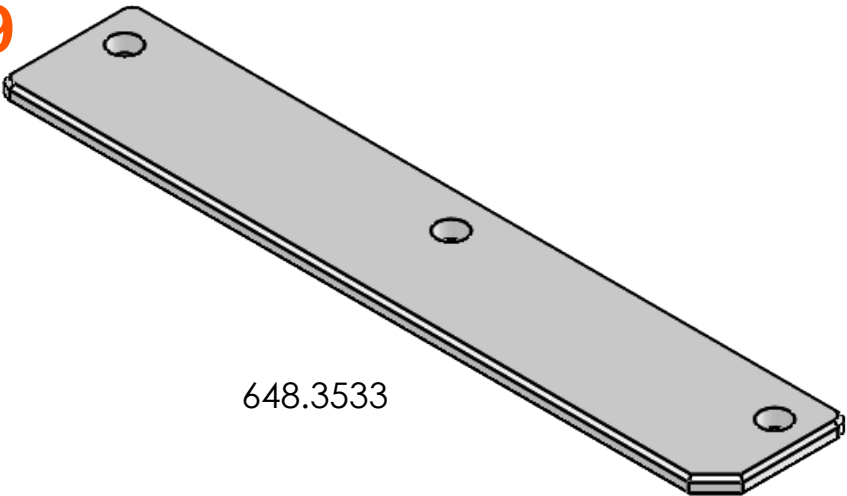
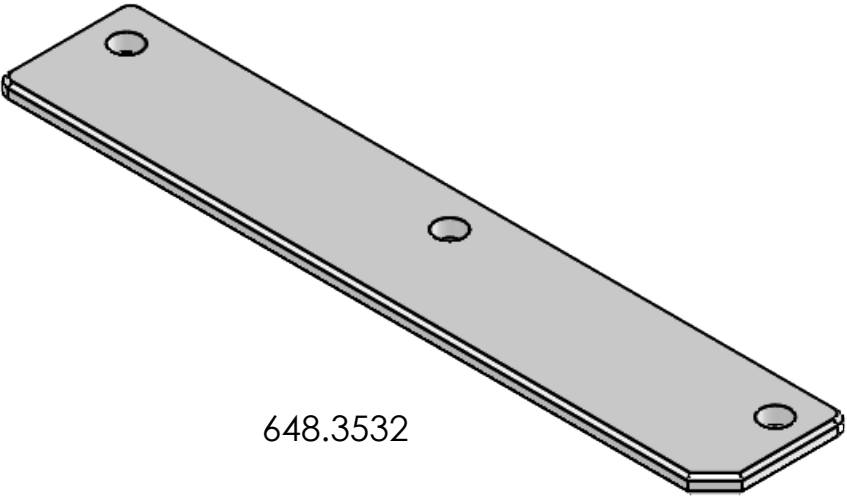
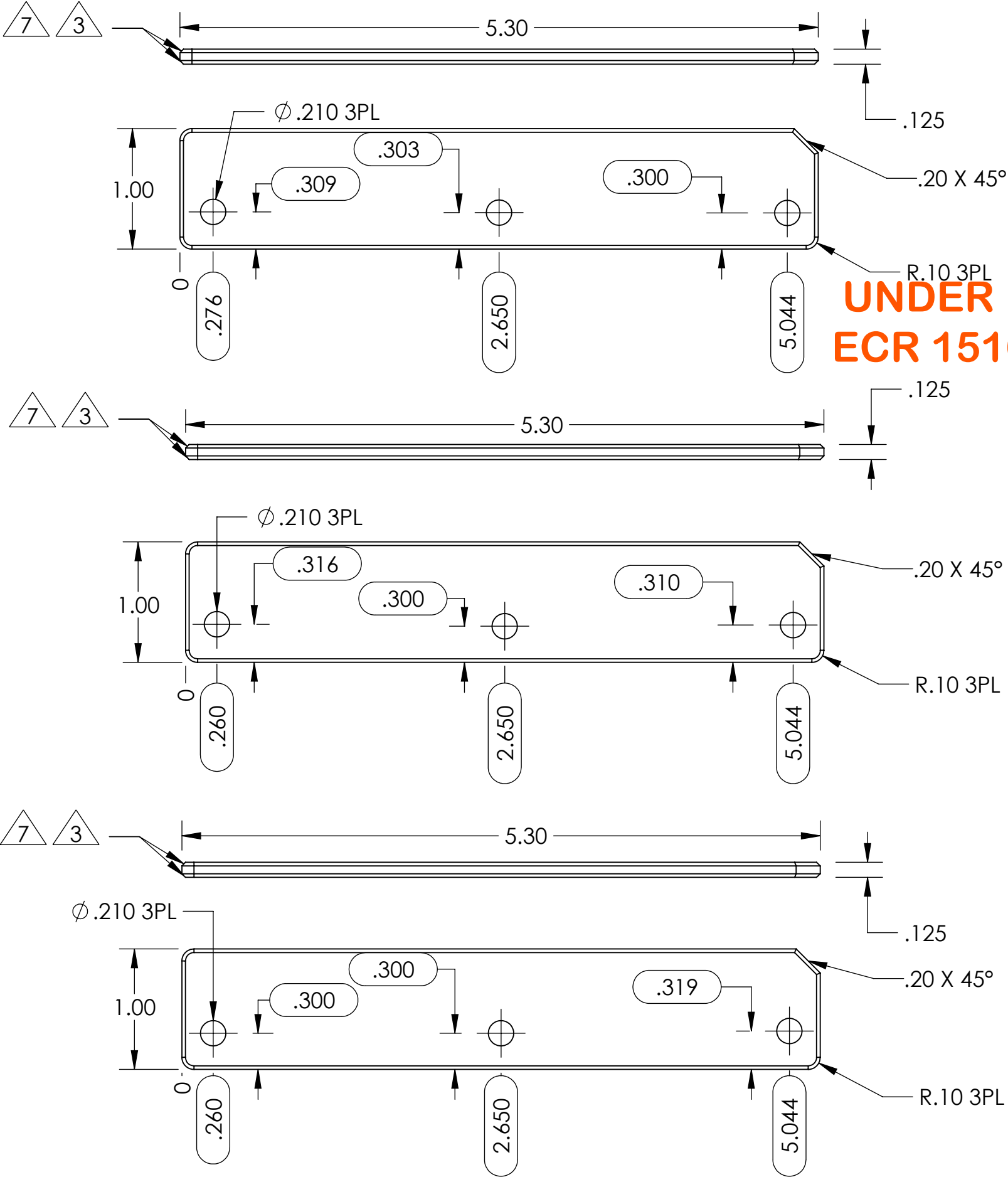


648.3506



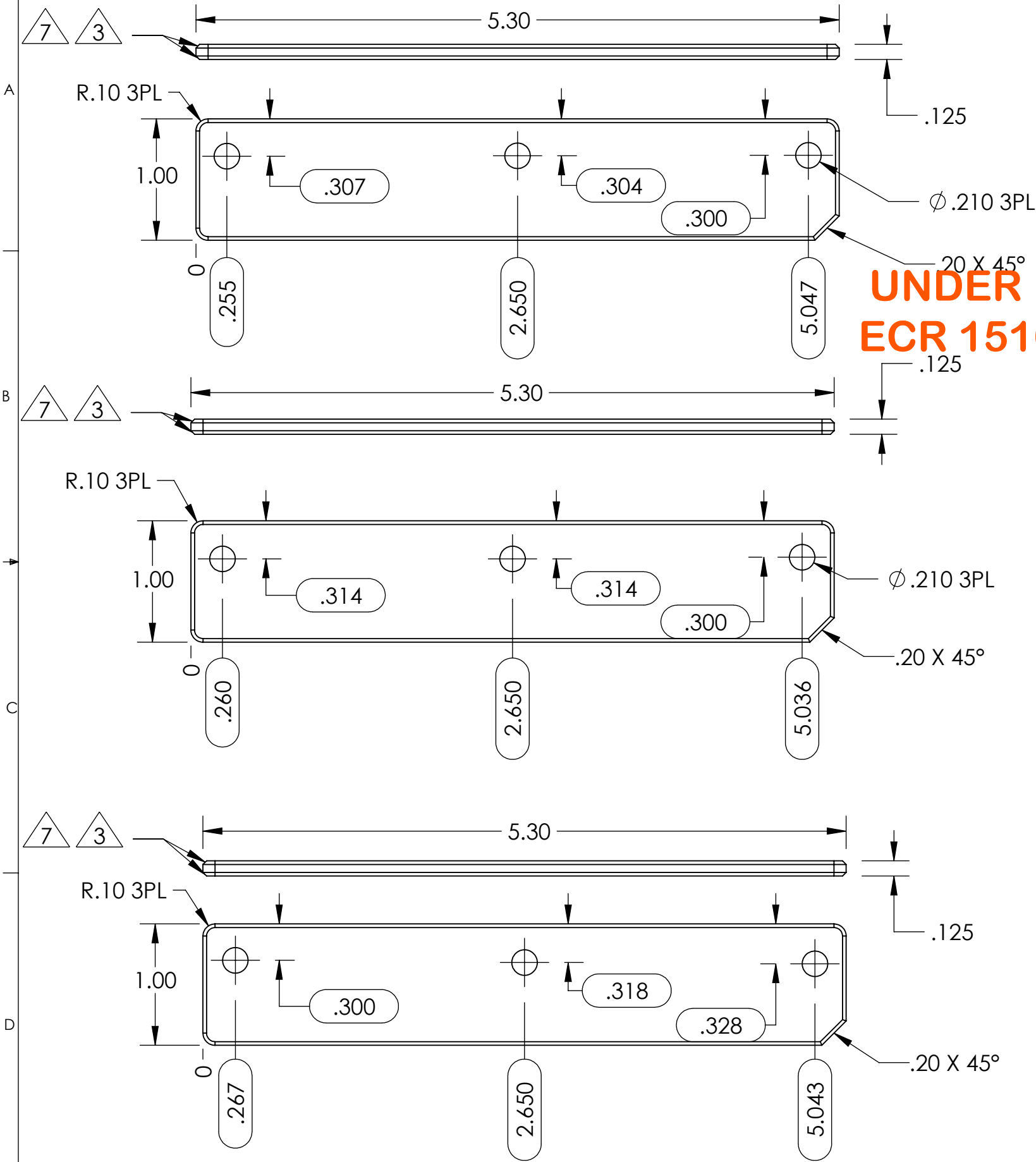
ORIGINAL DATE (MO-DA-YR) 08-19-10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E.ANDERSSON	CHECKER P.BRAVO		
DRAWING APPROVAL P.BRAVO 6-15-16		APICAL INDUSTRIES, INC. dba DART AEROSPACE	
CONTRACT No.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	REV. C
		CAGE CODE 07MZ6	DWG. NO. 648.3500
		SCALE NONE	SHEET 6 OF 12

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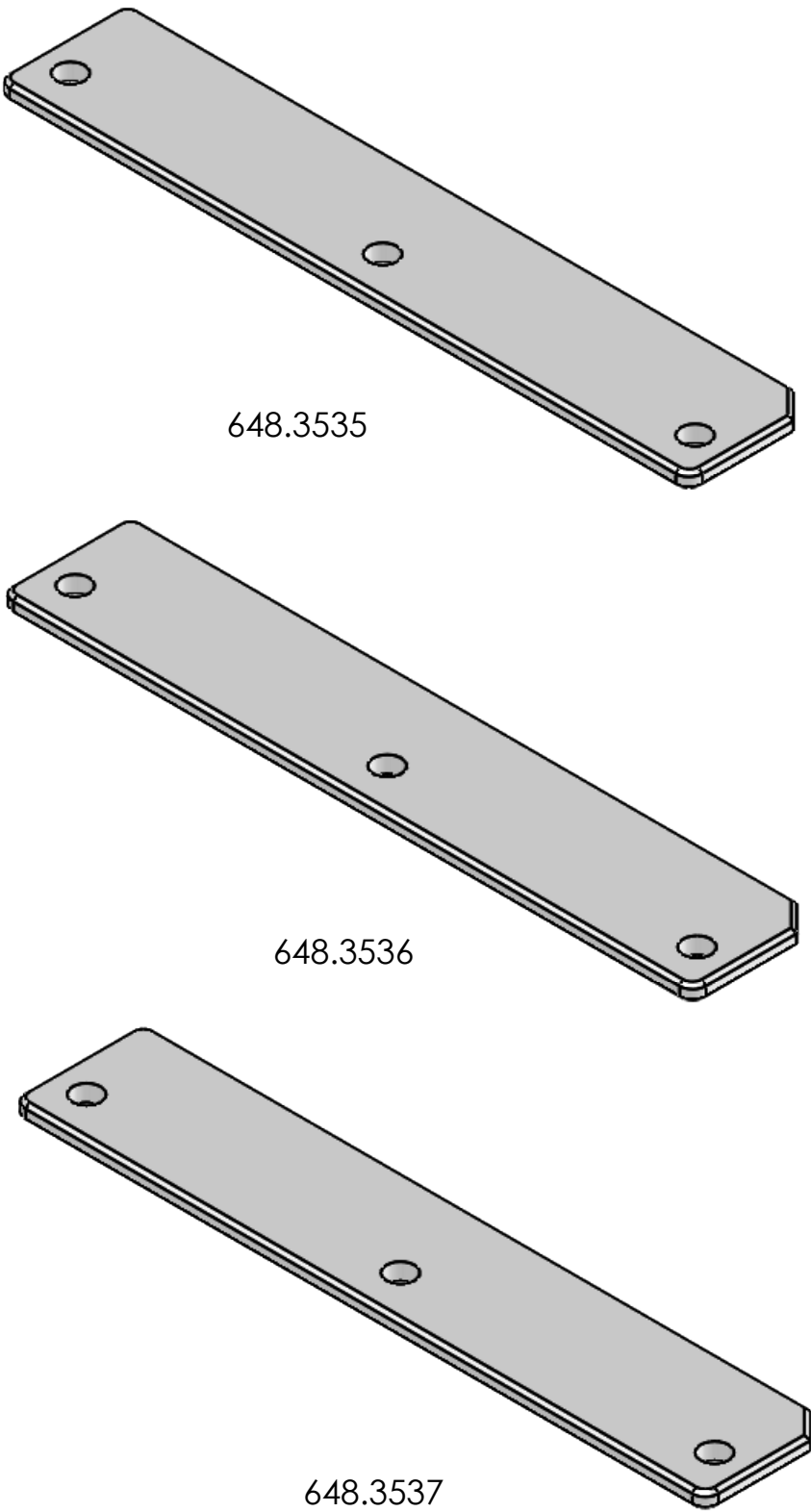


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DRAWN BY E.ANDERSSON	CHECKER P.BRAVO		
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CONTRACT No.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B 07MZ6	REV. C
		DWG. NO. 648.3500	
SCALE NONE		SHEET 7 OF 12	

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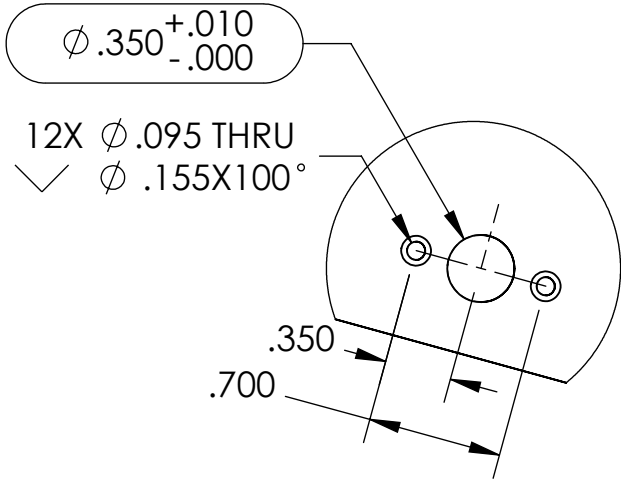


ORIGINAL DATE (MO-DA-YR) 08-19-10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E.ANDERSSON	CHECKER P.BRAVO		
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CAGE CODE 07MZ6		DWG. NO. 648.3500	SCALE NONE
SHEET 8 OF 12			

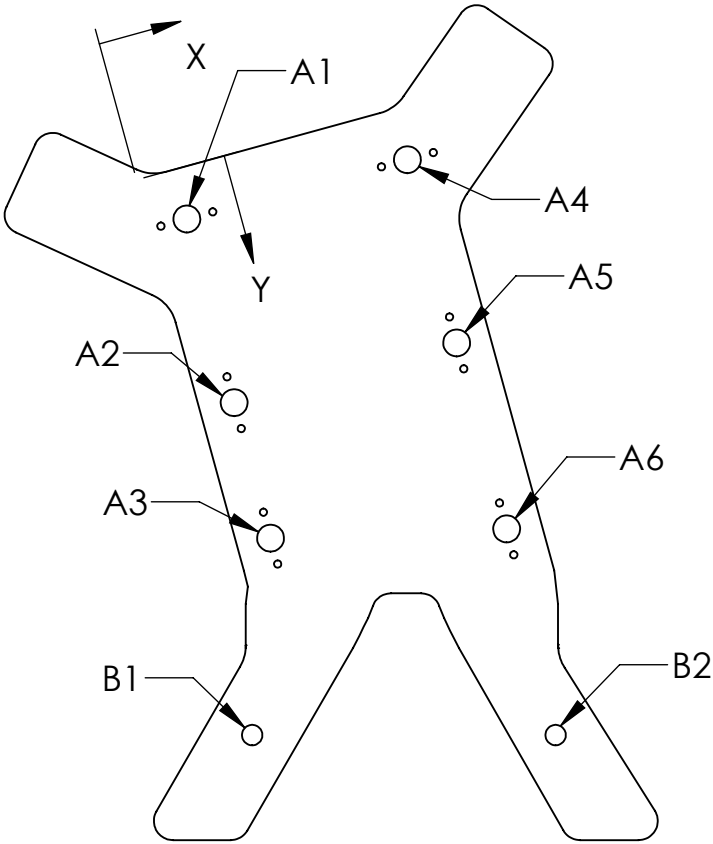
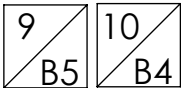
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TAG	X LOC	Y LOC	SIZE
A1	.497	.665	Ø .350 THRU
A2	.457	3.135	Ø .350 THRU
A3	.448	4.961	Ø .350 THRU
A4	3.470	.681	Ø .350 THRU
A5	3.457	3.151	Ø .350 THRU
A6	3.444	5.658	Ø .350 THRU
B1	-.461	7.370	Ø .266 THRU
B2	3.348	8.416	Ø .266 THRU

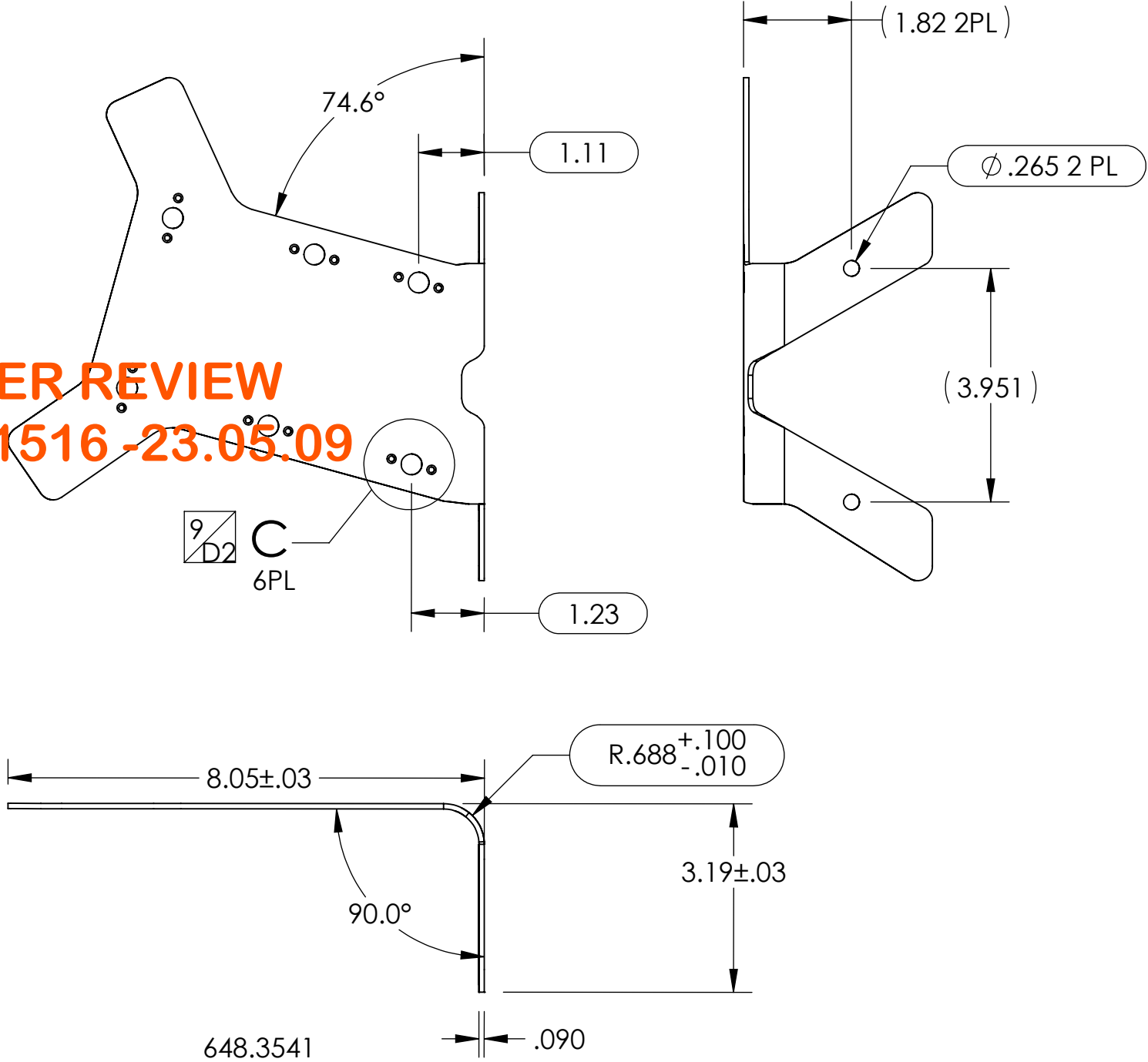
UNDER REVIEW
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DETAIL C

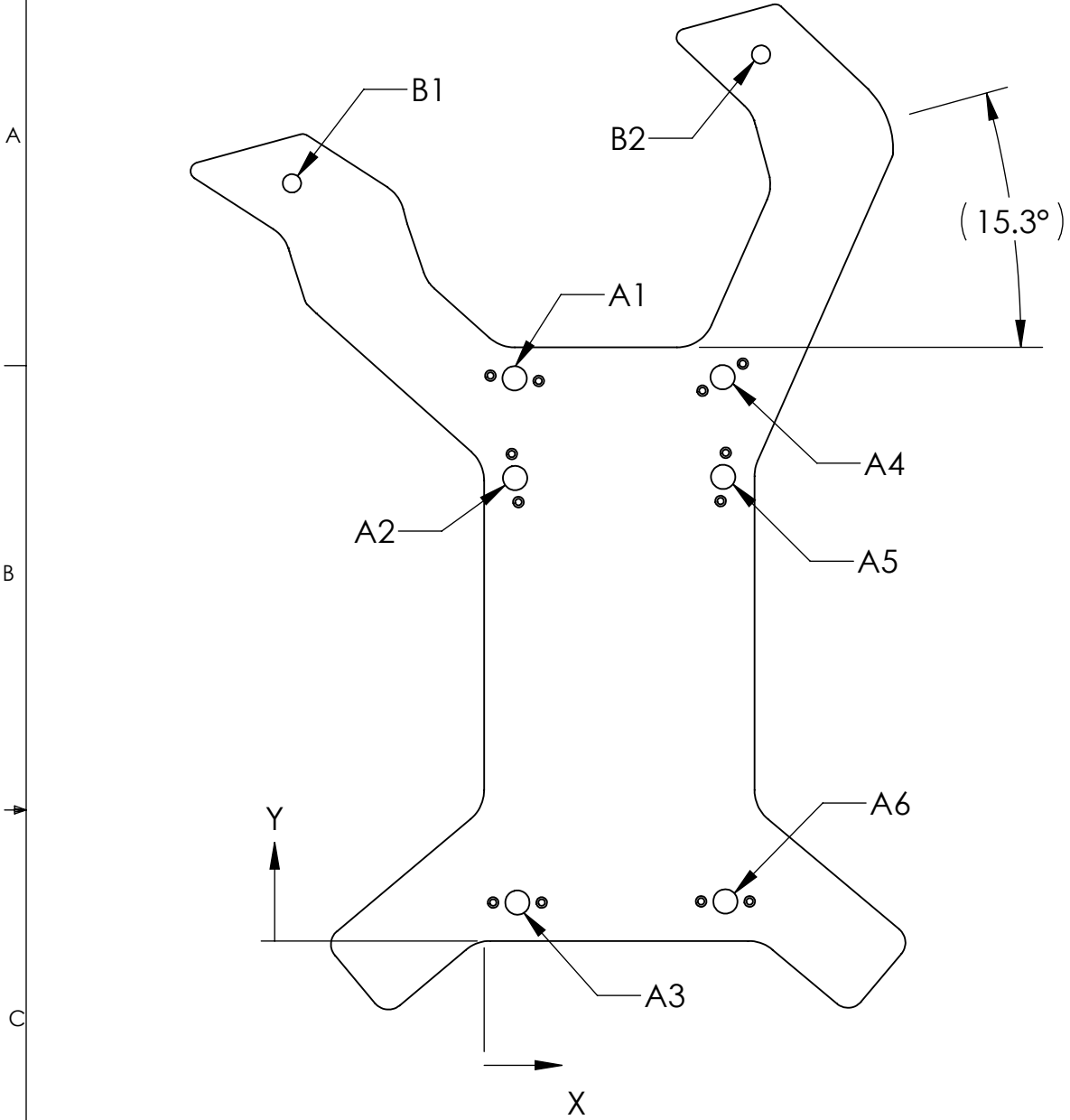


648.3541 - FLAT PATTERN

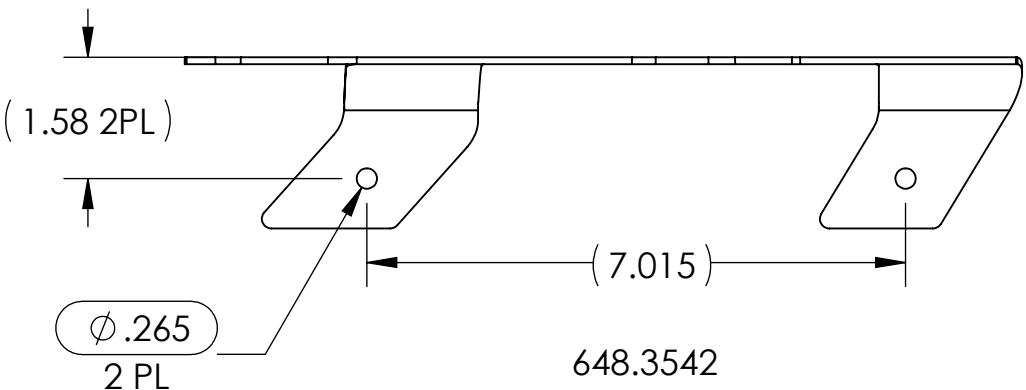
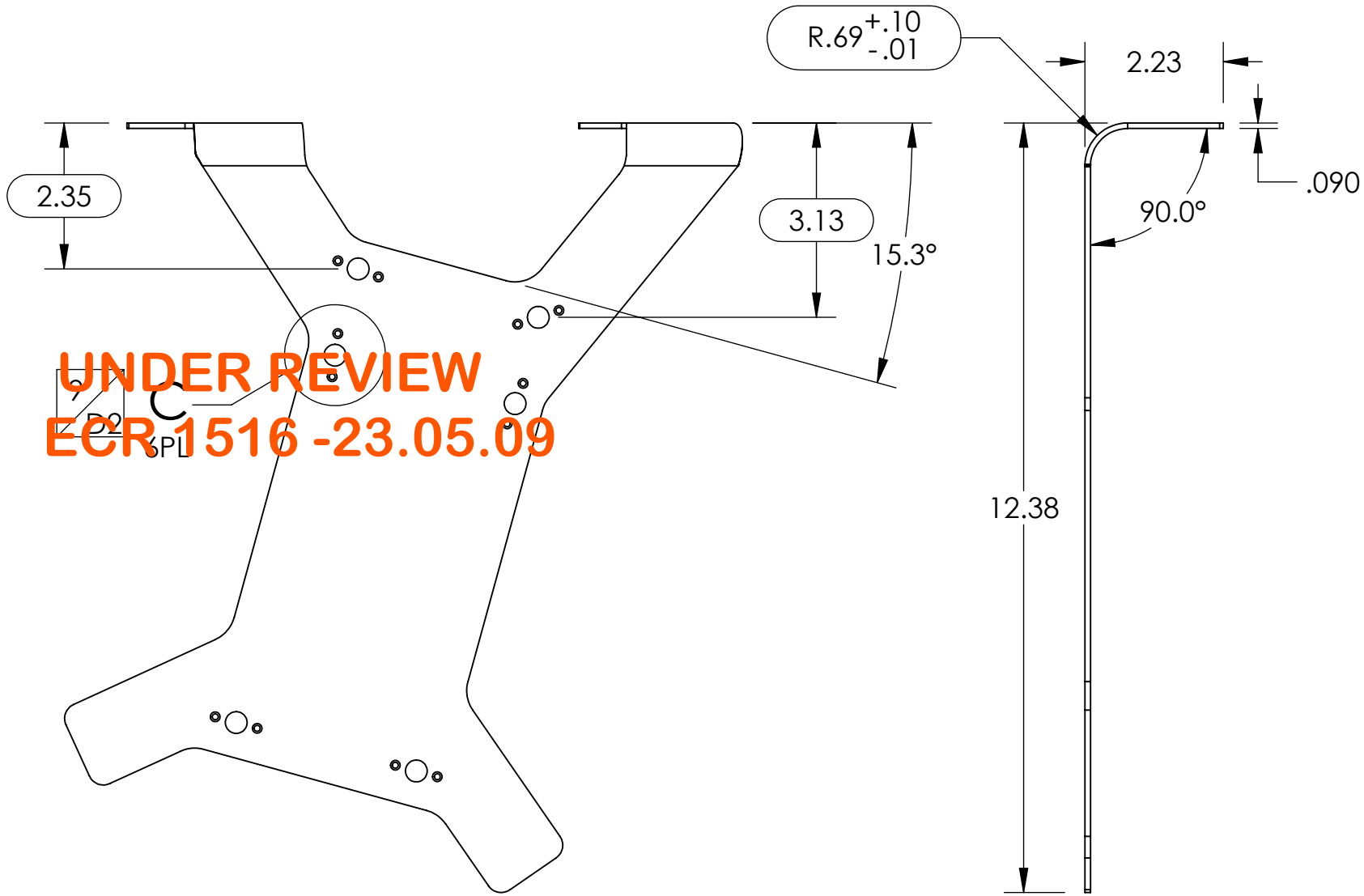


ORIGINAL DATE (MO-DA-YR) 08-19-10		3030 ENTERPRISE CT., SUITE A	
DRAWN BY E. ANDERSSON		VISTA, CA. 92081 (760)-724-5300	
CHECKER P. BRAVO		DART AEROSPACE APICAL INDUSTRIES, INC. dba DART AEROSPACE	
DRAWING APPROVAL P. BRAVO 6-15-16		SHEETMETAL	
CONTRACT No.		REV. C	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B	CAGE CODE 07MZ6
		DWG. NO. 648.3500	SCALE NONE
		SHEET 9 OF 12	

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TAG	X LOC	Y LOC	SIZE
A1	.440	8.111	Ø .350 THRU
A2	.448	6.673	Ø .350 THRU
A3	.480	.553	Ø .350 THRU
A4	3.440	8.126	Ø .350 THRU
A5	3.448	6.689	Ø .350 THRU
A6	3.480	.569	Ø .350 THRU
B1	-2.771	10.921	Ø .265 THRU
B2	3.994	12.778	Ø .265 THRU



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DRAWN BY E. ANDERSSON	CHECKER P. BRAVO			
DRAWING APPROVAL P. BRAVO 6-15-16				
CONTRACT No.		SHEETMETAL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B 07MZ6	DWG. NO. 648.3500	REV. C
SCALE NONE		SHEET 10 OF 12		

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13 648.3544

13 648.3543

ORIGINAL DATE (MO-DA-YR)		08-19-10
DRAWN BY E.ANDERSSON	CHECKER P. BRAVO	
DRAWING APPROVAL P. BRAVO 6-15-16		
CONTRACT No.		

DART

AEROSPACE

APICAL INDUSTRIES, INC.
dba DART AEROSPACE

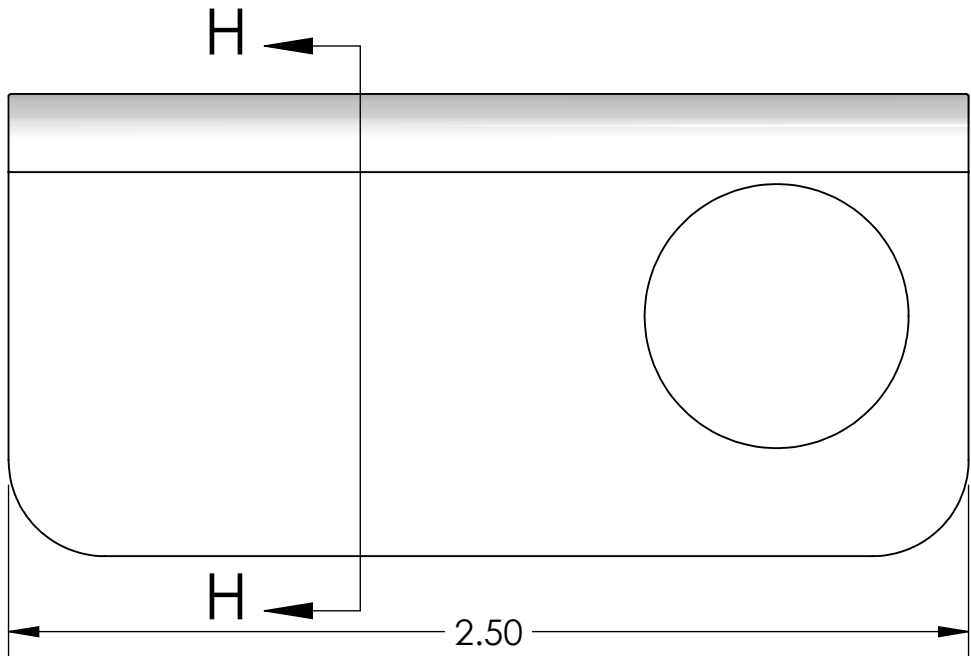
3030 ENTERPRISE CT.,
SUITE A
VISTA, CA. 92081
(760)-724-5300

SHEETMETAL

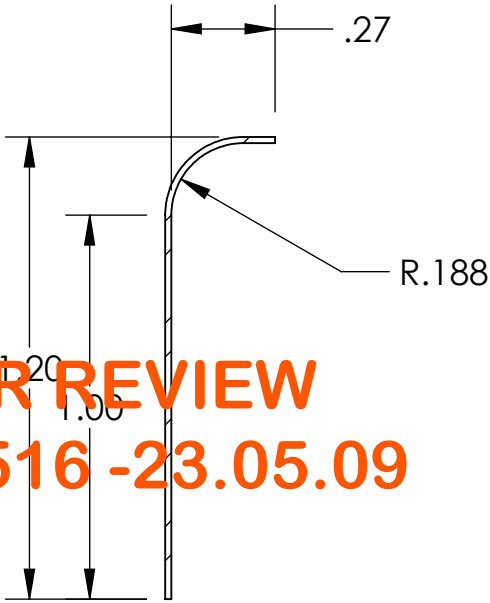
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°			
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SIZE	CAGE CODE	DWG. NO.	REV.
B	07MZ6	648.3500	C
SCALE NONE			SHEET 11 OF 12

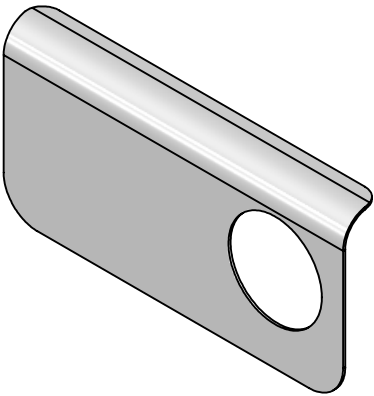
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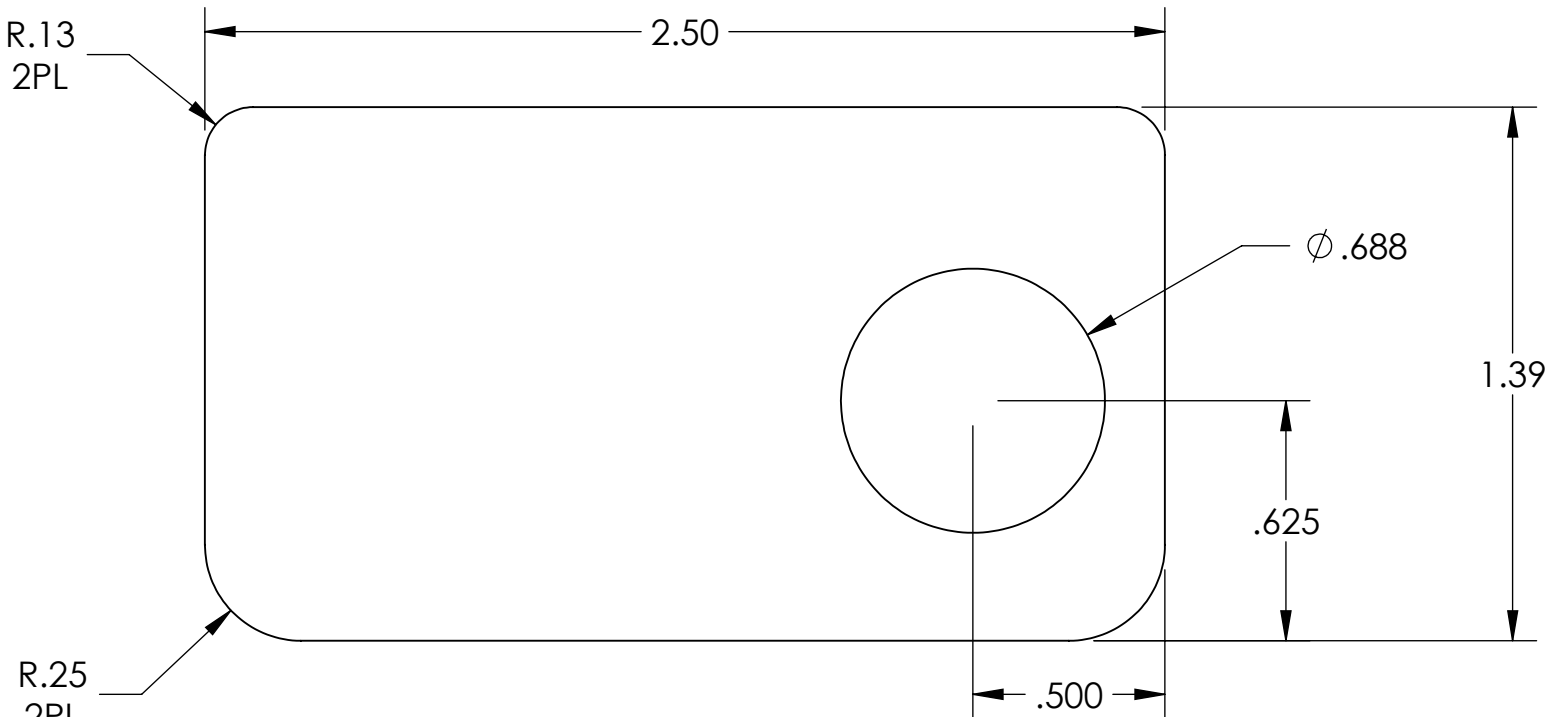
648.3547
648.3548 OPPOSITE



SECTION H-H
2 : 1



648.3547
648.3548 OPPOSITE



648.3547 AND 648.3548 FLAT PATTERN

ORIGINAL DATE (MO-DA-YR) 08-19-10		DART AEROSPACE APICAL INDUSTRIES, INC. dba DART AEROSPACE		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E.ANDERSSON	CHECKER P.BRAVO				
DRAWING APPROVAL P.BRAVO 6-15-16		CONTRACT No.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 648.3500	REV. C
		SCALE NONE		SHEET	12 OF 12